

Date: Thursday, 2/7/2008 10:54:20 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 37282	
Estimate Number : 10530	
P.O. Number :	Part Number : D2571
This Issue : 2/7/2008 S.O. No. :	Drawing Number : D2571 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 36322	Material :
Written By :	Due Date : 2/28/2008 Qty: 12 Um: Each
Checked & Approved By : <u>080207</u>	
Comment : Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: 12 34875

08/02/26

12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 34282 Double check by: SA

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

08/03/01

12

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

08/03/01

12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/03/01

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: N/A Fault Category: Prod / Machine / Part NCR: Yes No DQA: D Date: 08/03/06  
 QA: N/C Closed: HJ Date: 08/03/06

NCR: <u>37282</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/02/07</u>	<u>2</u>	WALL THICKNESS ON SKIDTUBE IS 0.111 INSTEAD OF 0.125". THICKNESS AT SKIDTUBE RIDGE IS 0.361" IN SPOTS. R.C. operator error.	<u>CP</u> <u>08.02.27</u> <u>per</u> <u>081042</u>	SCRAP PART. REPLACE.	<u>me</u> <u>08/03/06</u>	<u>/</u> <u>0803-06</u>	<u>CP</u> <u>08.02.27</u> <u>per</u> <u>081042</u>	<u>/</u> <u>0803-06</u>

NOTE: Date & initial all entries

Date: Thursday, 2/7/2008 10:54:20 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 37282

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BC 08-03-03

(12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-03-03

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FA 08/03/04

(2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-L

M-L

08/03/04

(12X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 438

8/3/5

50

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/06

(12)

Job Completion



mi 2008/3/05

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

LOSER

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	37282
<b>Description:</b> Saddle, Fwd Outboard		<b>Part Number:</b>	D2571
<b>Inspection Dwg:</b> D2571 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	<del>DT8682</del>	.442	.442	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.508	.497	.500	.498		
G	0.257	0.262	<del>DT8683</del>	0.259	0.260	0.260	.260		
H	0.375	0.380	<del>DT8684</del>	.377	0.377	0.377	.377		
I	0.490	0.510		.501	0.501	0.500	.501		
J	1.174	1.184		1.178	1.180	1.180	1.180		
K	0.558	0.578		.566	0.560	0.568	.567		
L	1.174	1.184		1.178	1.180	1.180	1.180		
M	1.490	1.500		1.494	1.496	1.496	1.496		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.874	3.874	3.874		
P	0.115	0.135		.122	0.126	0.127	.126		
Q	0.115	0.135		.135	0.135	0.135	.135		
R	0.240	0.260		.250	0.253	0.253	.253		
S	0.115	0.135		0.132	0.135	0.133	.133		
T	0.178	0.198		.188	0.188	0.188	.188		
U	2.940	2.980		2.959	2.956	2.960	2.960		
V	0.230	0.250		.241	0.243	0.238	.242		
W	0.115	0.135		.120	0.131	0.127	.127		
X	0.308	0.313		.309	.308	.310	.310		
Y	0.760	0.765		.760	.762	.762	.762		
Z	0.352	0.372		.362	.362	.365	.362		
AA	0.470	0.530		.500	0.500	0.500	.500		
AB	0.615	0.635		.634	.623	.633	.633		
AC	0.053	0.073		.063	0.063	0.063	.063		
AD	0.240	0.260		.246	0.251	0.247	.247		
AE	1.375	1.395		1.388	1.385	1.390	1.385		
AF	0.115	0.135		.133	0.133	0.133	.135		
AG	0.240	0.280		.251	0.260	0.255	.255		
AH	0.240	0.260		.246	0.253	0.248	.253		
AI	2.000	2.020		2.002	2.000	2.003	2.004		
AJ	0.023	0.043		0.037	0.030	.050	.050		
Accept/Reject									

Measured by:	One / SA
Date:	08/02/28

Audited by:	BE
Date:	08-03-03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

1.332  
1.625  
2-165 Sg/A

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>37282</b>
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	<b>D2571</b>
<b>Inspection Dwg:</b> D2571 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
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A	0.438	0.443	<del>DT8682</del>	.442	.442	.442	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.004	8.002		
F	0.490	0.510		.493	.493	.493	.493		
G	0.257	0.262	<del>DT8683</del>	.258	.258	.258	.258		
H	0.375	0.380	<del>DT8684</del>	.375	.375	.375	.375		
I	0.490	0.510		.497	.495	.495	.502		
J	1.174	1.184		1.175	1.175	1.175	1.175		
K	0.558	0.578		.566	.570	.570	.571		
L	1.174	1.184		1.175	1.175	1.175	1.175		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.498	2.498	2.498	2.495		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.127	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.234	.253	.252		
S	0.115	0.135		.133	.130	.131	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.242	.241	.241	.241		
W	0.115	0.135		.131	.132	.132	.123		
X	0.308	0.313		.309	.305	.309	.309		
Y	0.760	0.765		.762	.762	.766	.766		
Z	0.352	0.372		.367	.362	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.258	.260	.260	.260		
AE	1.375	1.395		1.390	1.390	1.389	1.389		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.255	.255	.255	.255		
AH	0.240	0.260		.251	.251	.251	.251		
AI	2.000	2.020		2.003	2.003	2.003	2.002		
AJ	0.023	0.043		.030	.030	.033	.033		
Accept/Reject									

Measured by:	SA
Date:	08/02/28

Audited by:	RF
Date:	08-03-03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

*[Handwritten signature]*

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	37282
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b>	D2571
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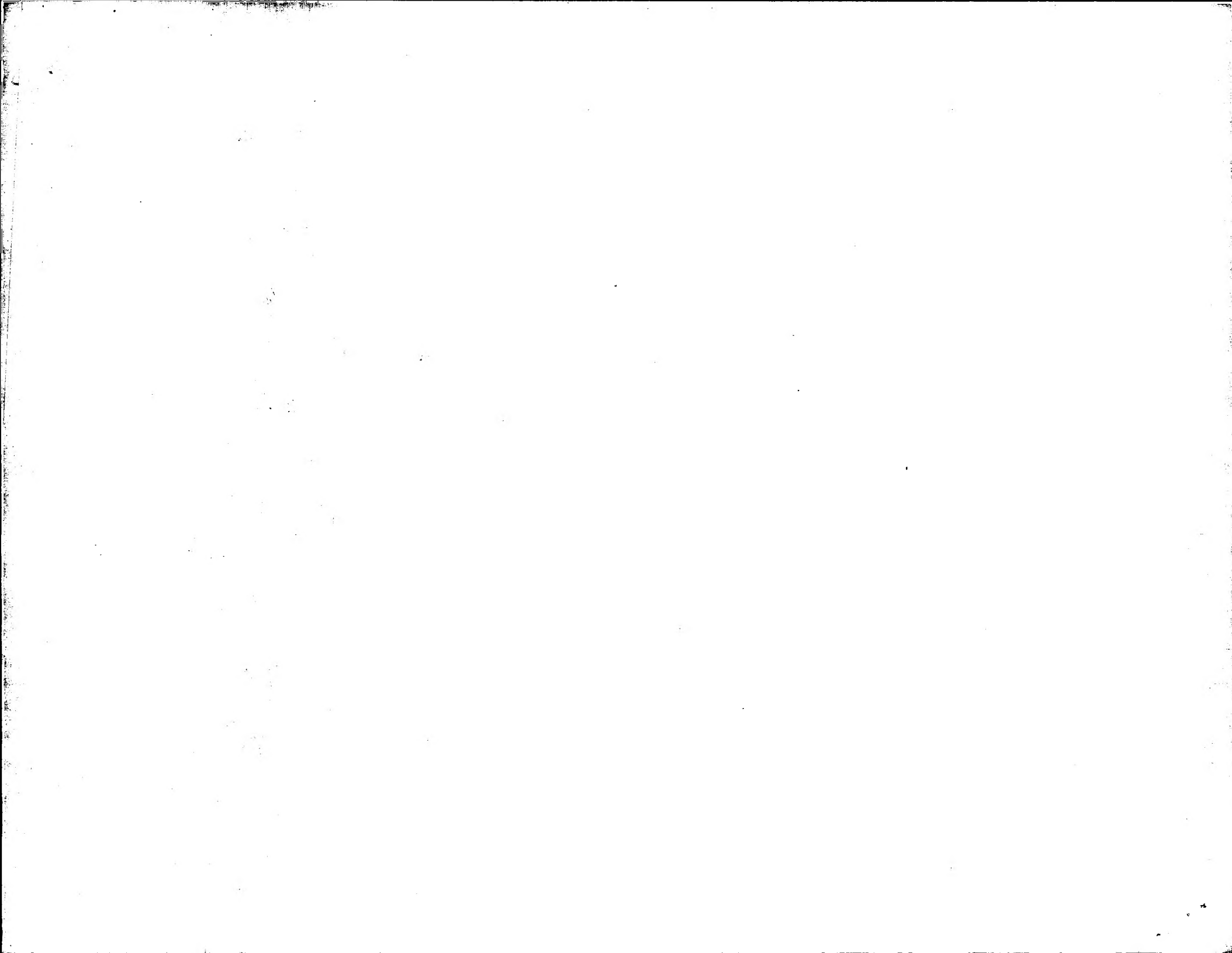
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B	1.745	1.755		1.750	1.750	1.749	1.750		
C	3.495	3.505		3.506	3.506	3.506	3.506		
D	1.745	1.755		1.756	1.750	1.749	1.750		
E	7.990	8.010		8.002	8.000	8.000	8.000		
F	0.490	0.510		1.501	.501	.501	.509		
G	0.257	0.262	<del>DT8683</del>	1.258	.260	0.259	.259		
H	0.375	0.380	<del>DT8684</del>	.377	.378	0.378	.377		
I	0.490	0.510		.506	.506	0.506	.506		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		.576	.568	0.568	.566		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.494	1.494	1.493	1.493		
N	2.495	2.505		2.506	2.506	2.506	2.506		
O	3.869	3.879		3.871	3.871	3.873	3.872		
P	0.115	0.135		0.125	.127	0.128	.126		
Q	0.115	0.135		0.135	.135	0.135	.135		
R	0.240	0.260		0.250	.253	0.253	.252		
S	0.115	0.135		0.130	.133	0.130	.134		
T	0.178	0.198		0.188	.188	0.188	.188		
U	2.940	2.980		2.958	2.958	2.958	2.958		
V	0.230	0.250		0.239	.247	0.238	.248		
W	0.115	0.135		0.126	.127	0.118	.130		
X	0.308	0.313		.309	.309	.309	.309		
Y	0.760	0.765		.766	.766	.766	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.500	.506	.500	.500		
AB	0.615	0.635		.632	.632	.628	.630		
AC	0.053	0.073		.063	.063	0.063	.063		
AD	0.240	0.260		.246	.257	0.247	.257		
AE	1.375	1.395		1.392	1.391	1.391	1.382		
AF	0.115	0.135		.133	.133	0.135	.135		
AG	0.240	0.280		.257	.257	0.260	.260		
AH	0.240	0.260		0.249	0.256	0.248	.256		
AI	2.000	2.020		2.005	2.004	2.007	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>[Signature]</i>
Date:	08/03/01

Audited by:	<i>[Signature]</i>
Date:	05-03-03







Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>






05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |   |
|---|---|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125  |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)   |
|  | CHAMFER 0.063" x 45° ALL AROUND   |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)  |

 $\triangle E$ 

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DRAWN BY	REV. 10000	
DS	PH	<b>DART</b>	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2571	REV. _____ SHEET 1 OF 2
DATE 05.07.13	TITLE OUTER FWD SADDLE		SCALE 2

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DETAIL C  
SCALE 4:3

SECTION A-A

SHOP COPY  
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WORK UNDER  
NO. 37282

